

Date: Monday, 4/9/2007 12:25:23 PM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR WINDOW
Job Number : 30900	
Estimate Number : 10457	
P.O. Number : N/A	Part Number : D32121
Title Issue : 4/9/2007 S.O. No. : N/A	Drawing Number : D3212 REV B
First Rev. : NC	Project Number : N/A
First Issue : 2/23/2007 Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29031	Material : Multiples of 4
Written By : <u>EC 07.04.09</u>	Due Date : 3/14/2007
Checked & Approved By :	Qty: ²⁸ 10 Um: Each
Comment :	
Est Rev: A New Issue 05-11-09 JLM	
Est Rev: B Water jet/ ecn798 06-05-08 EC	
est rev C back on haas 07.04.09 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 1.0232 sf(s)/Unit Total: 10.2323 sf(s)
 Material: 0.125" Polycast Sheet
 (M-ACRYLIC-S.125)
 Identify as D3212-1
 Batch: M104436

SD 07.05.15

2.0	WATER JET	FLOW WATER JET
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HAAS



Comment: FLOW WATER JET
 1-Cut as per Dwg D3212
 Dwg Rev: _____
 Prog Rev: _____

2-Deburr if needed

SD 07.05.16 (22)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.05.16 (22)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

En 07.05.16 (22)

5.0	D27281	Dart Logo label small
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Qty Part # Description Batch
 1 D2728-1 Dart Logo label B24215

ml 07/05/17

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Date: Monday, 4/9/2007 12:25:24 PM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR WINDOW

Job Number: 30900

Part Number: D32121

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

2-Install label as per Dwg D3212

3- polish abrasion scratches if necessary..

X22

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1-Wrap in plastic wrap after inspection

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SJ 213

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 07/05/29

DART AEROSPACE LTD		Work Order:	30900
Description: Floor Window		Part Number:	D3212-1
Inspection Dwg: D3212 Rev: XB 07.01.22		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.734	+/-0.005	12.730	/		Tape	
6.367	+/-0.005	6.367	/			
0.625	+/-0.005	.627	/			
0.156	+0.005/-0.000	.157	/			
R0.25	+/-0.030	R.25	/			
8.150	+/-0.005	8.159	/			
3.750	+/-0.005	3.748	/			
0.313	+/-0.010	.314	/			
15.14	+/-0.030	15.14	/		Tape	
12.520	+/-0.005	12.520	/		Tape	
6.260	+/-0.005	6.259	/			
1.312	+/-0.005	1.312	/			
0.313	+/-0.010	.314	/			
3.750	+/-0.005	3.750	/			
8.150	+/-0.005	8.150	/			
8.462	+/-0.005	8.463	/			
9.09	+/-0.030	9.100	/			

Measured by: SD	Audited by: En	Prototype Approval:	N/A
Date: 07.05.16	Date: 07.05.16	Date:	N/A

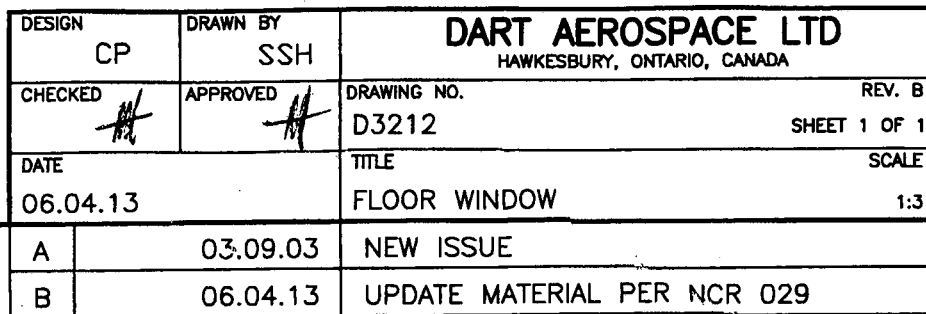
Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	TF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3212-1 PAR #: N/A Fault Category: Prod / Machine parts NCR: (Yes) No DQA: D Date: 07/05/30
 QA: N/C Closed: HA Date: 07.05.30

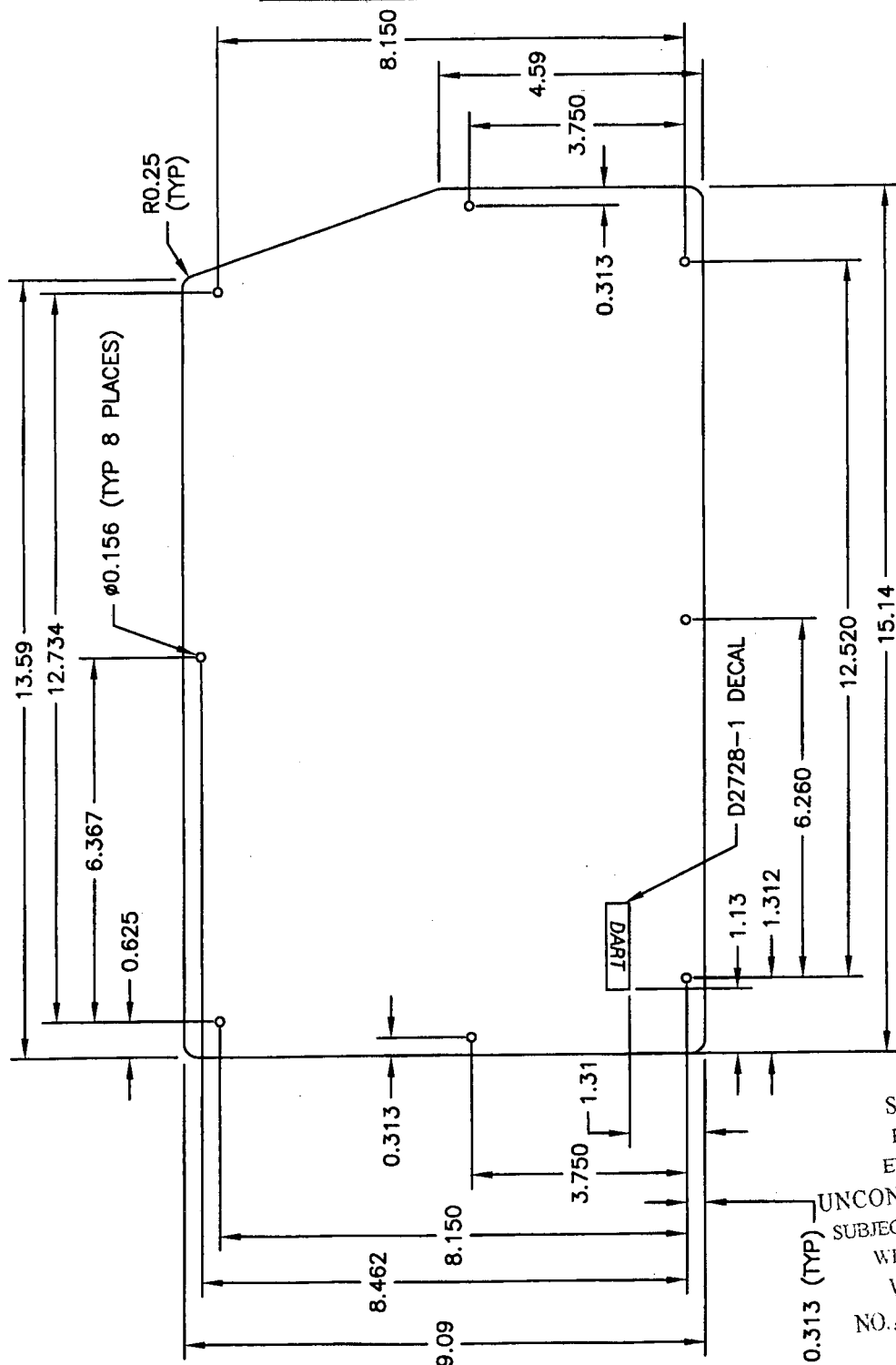
NCR: <u>30900</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.05.16	2.0	- 2 parts scrap - Sad origin. - 4 parts, blanks cut too short.	<i>[Signature]</i> 05/04/2	65 scrap, extra blanks already cut, per qty of 10. Now 22	<i>[Signature]</i> 07.05.16	<i>[Signature]</i> 07.05.16	<i>[Signature]</i> 05/04/2	<i>[Signature]</i> 07.05.16
07.05.29	1.0	Incorrect material was used to make the windows. The size was correct, but material was not correctly identified to specifications. Material used was purchased for tooling.	<i>[Signature]</i> 05/04/2	ensure to clearly/specify I.D. material when it's received. Scrap & destroy windows. see w/o 32287	<i>[Signature]</i> 07.05.29	<i>[Signature]</i> 07.05.29	<i>[Signature]</i> 05/04/2	<i>[Signature]</i> 07.05.29
07.05.29	<i>[Signature]</i>	<i>[Signature]</i>			<i>[Signature]</i> 07.05.29			

NOTE: Date & initial all entries



D3212-1 FLOOR WINDOW

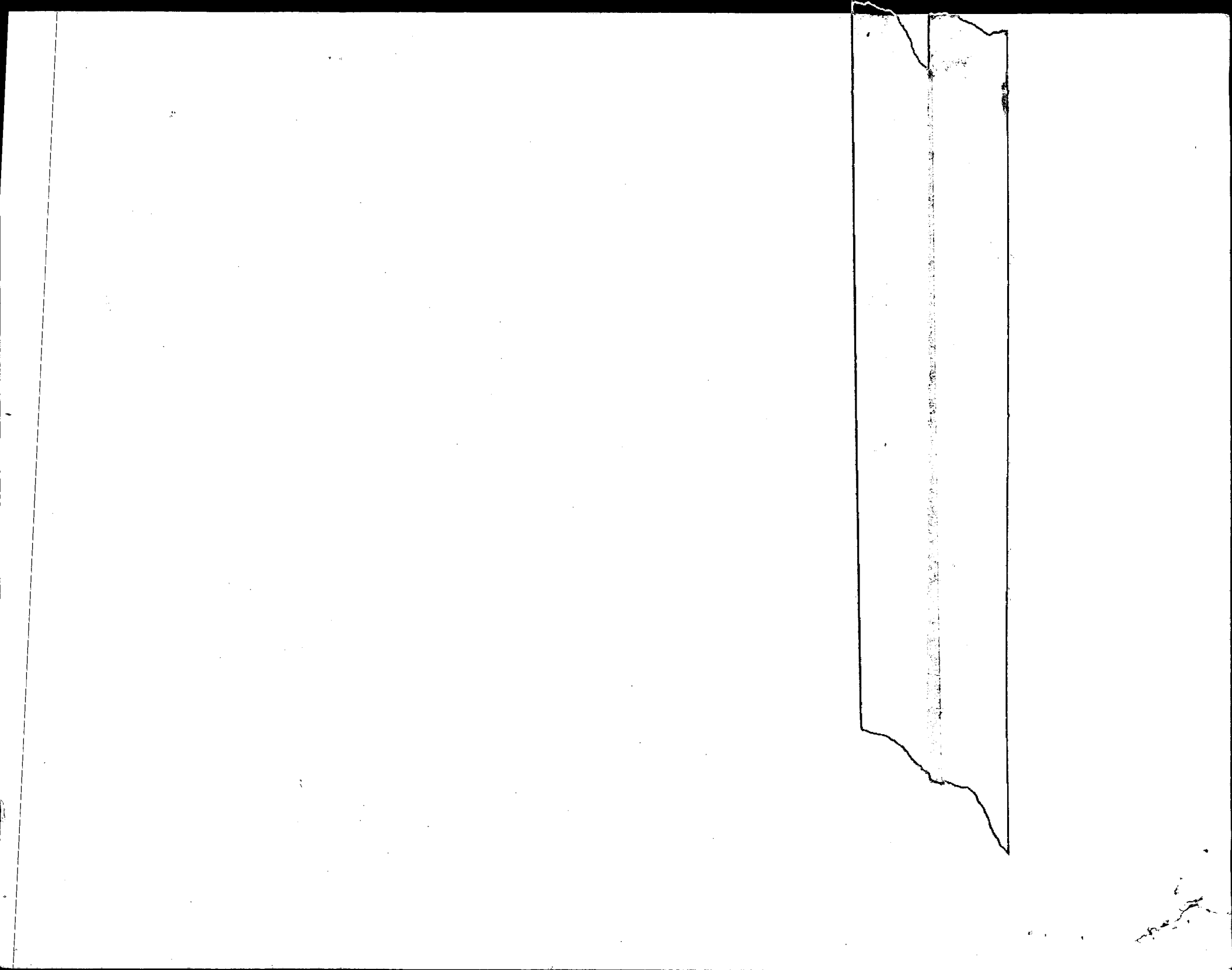
- 1) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1
- 2) DIMENSIONS ARE IN INCHES AND ARE FOR REFERENCE ONLY
- 3) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK (REF. DART SPEC. M-ACRYLIC-S.125)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30900

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GE Polymershapes

1250 OLD INNES RD. UNIT 519 OTTAWA ONT. K1B 5L3

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE LTD

DATE: May 24th, 2007

YOUR PURCHASE ORDER: 03749

OUR SHIPPER NO: 077226

LINE ITEM #: 001

QUANTITY: 6

DESCRIPTION: FF CLEAR - PAPERMASK 3.0MM X 49 X 97

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:
FF - PAPER

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

SALES REPRESENTATIVE SIGNATURE

ALEXANDRA DAY
CUSTOMER SERVICE REPRESENTATIVE